

July-14-15 11:46:51 AM

Page 1

Quality Control

Dush
~~PRELIMINARY ISSUE~~ *Rev A*
~~1334659~~

July-14-15 11:46:52 AM

Page 2

```
Setup  Start  *NS1*
      Stop   *NS2*
```

Start Date:	14/07/2015	Start Qty:	3.00	*3*
Required Date:	15/07/2015	Req'd Qty:	2.00	*2*

Cust Item ID:
Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run	Start	*NR1*
	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140 QC8- Inspect parts - second check

0.00

140

QC

Memo

0.00

Quality Control

② 15-02-15 DAS
as per D5383-1 9
9-89

150 Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

2 FF JUL 16 2015

160 QC7-Inspect Chemical Conversion Coat

0.00

160

OC

Memo

0.00

Quality Control

DAS
30
9-89

2 JUL 15 2015

Work Order ID 134652

134652

Page 3

July-14-15 11:46:52 AM

Item ID: D5283-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: PRELIM Stop *NS2*
 Item Name: Basket Clamp Assembly
 Start Date: 14/07/2015 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 15/07/2015 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
170									
Powdercoat	Memo M 131545.	0.00							
Powder Coating	***MASK BEARING BORE PRIOR TO POWDER COAT***								
	START TIME: 8:40								
	OVEN TEMPERATURE: 320°								
	FINISH TIME: 9:10								
180	QC3- Inspect Part Finish	0.00							
180									
QC	Memo	0.00							
Quality Control									
190		0.00							
190									
Small Fab	Memo	0.00							
Small Fab	PRESS FIT BEARING AND STAKE 4 PLACES PER SIDE AS PER DWG								

2 0 15-8-16 2300

2 FF JUL 16 2015

2 FF JUL 16 2015

Work Order ID 134652

134652

Page 4

July-14-15 11:46:52 AM

Item ID: D5283-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: PRELIM Stop *NS2*
 Item Name: Basket Clamp Assembly
 Start Date: 14/07/2015 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 15/07/2015 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC5- Inspect part completeness to step on W/O	0.00							
200						②		JUL 16 2015	DAS 9 9-89
QC	Memo	0.00							
Quality Control									
210	Identify as per dwg & Stock Location <u>Relim</u>	0.00							
210						②		JUL 16 2015	DAS 9 9-89
Packaging	Memo ST525	0.00							
Packaging						① JA		AUG 14 2015	DAS 28 9-89
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

MCS JUL 16 2015

POSITIVE RECALL

EFFECTIVE 15-07-14 AUTH [Signature]
 RELEASED 15-08-13 DATE 9
 9-89

Rev A

Picklist Print

July-14-15 11:46:50 AM

Page 1

Work Order ID: 134652

134652

Parent Item: D5283-041

D5283-041

Parent Item Name: Basket Clamp Assembly

Start Date: 14/07/2015

Required Date: 15/07/2015

Start Qty: 3.00

Required Qty: 2.00

Comments: IPP REV:A 15.07.06 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2611		Manufactured	No				Each	25.0000		3			
-------	--	--------------	----	--	--	--	------	---------	--	---	--	--	--

D2611

Bearing

**

FF

JUL 16 2015

Location

Loc Qty

Loc Code

ST008A

25

131130

15

134006

10

2

M6061T6B1.500X04.00
0

Purchased

No

f

18.9500

1.578947

M6061T6B1 500X04 000

6061T6 Bar 1.500 x 4.00

**

15/07/15

Location

Loc Qty

Loc Code

MAT004

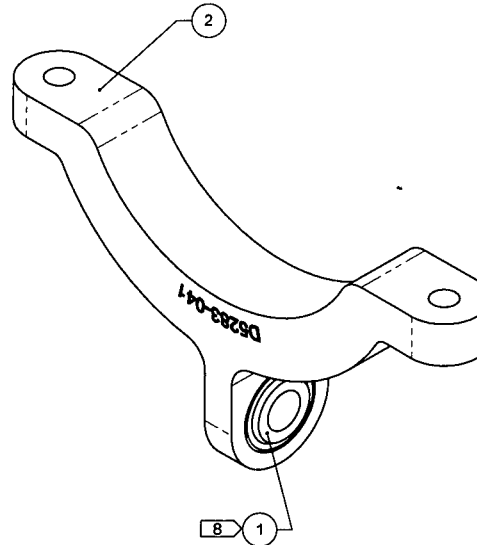
18.95

MT26075

18.95

1,933

ITEM	QTY	P/N	DESCRIPTION
	X	D5283-041	BASKET CLAMP ASSY
1	1	D2611	BEARING
2	1	D5283-1	BASKET CLAMP



D5283-041 BASKET CLAMP ASSY

NOTES:

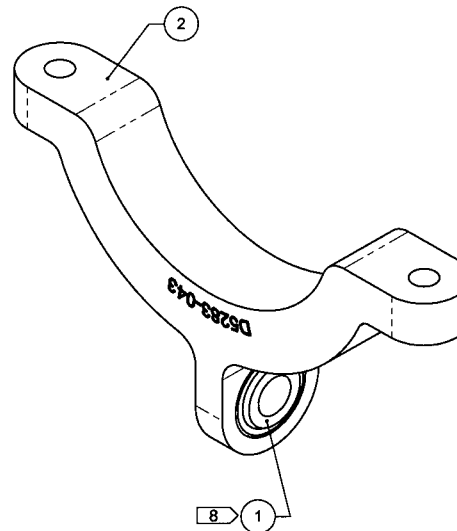
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs
- 8) PRESS FIT D2611 BEARING AND STAKE 4 PLACES PER SIDE

REVISED

A	NEW ISSUE		DB	15.06.30
REV.	DESCRIPTION		BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D5283 TITLE BASKET CLAMP ASSY COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	REV. A20	SHEET 1 OF 6
DRAWN	DB			
CHECKED	AP			
MFG. APPR.	JLM			
APPROVED				SCALE
DE APPR.				NTS
DATE	15.06.30			

UNAPPROVED

ITEM	QTY	P/N	DESCRIPTION
	X	D5283-043	BASKET CLAMP ASSY
1	1	D2611	BEARING
2	1	D5283-3	BASKET CLAMP



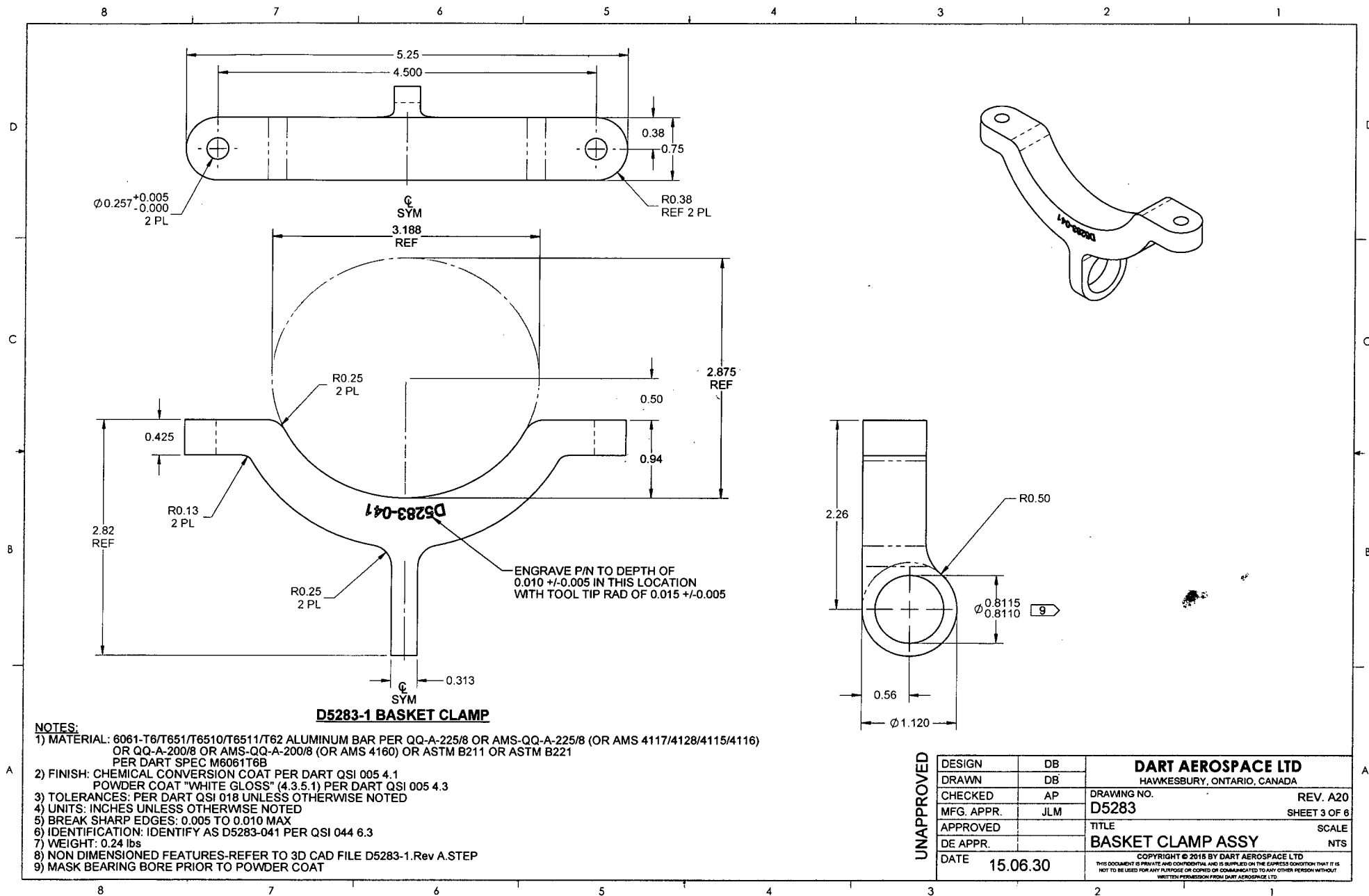
D5283-043 BASKET CLAMP ASSY

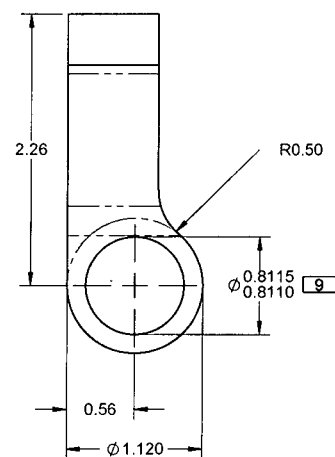
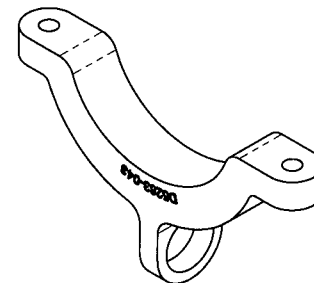
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs
- 8) PRESS FIT D2611 BEARING AND STAKE 4 PLACES PER SIDE

UNAPPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. A20
MFG. APPR.	JLM	D5283	SHEET 2 OF 6
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DE APPR.		BASKET CLAMP ASSY	NTS
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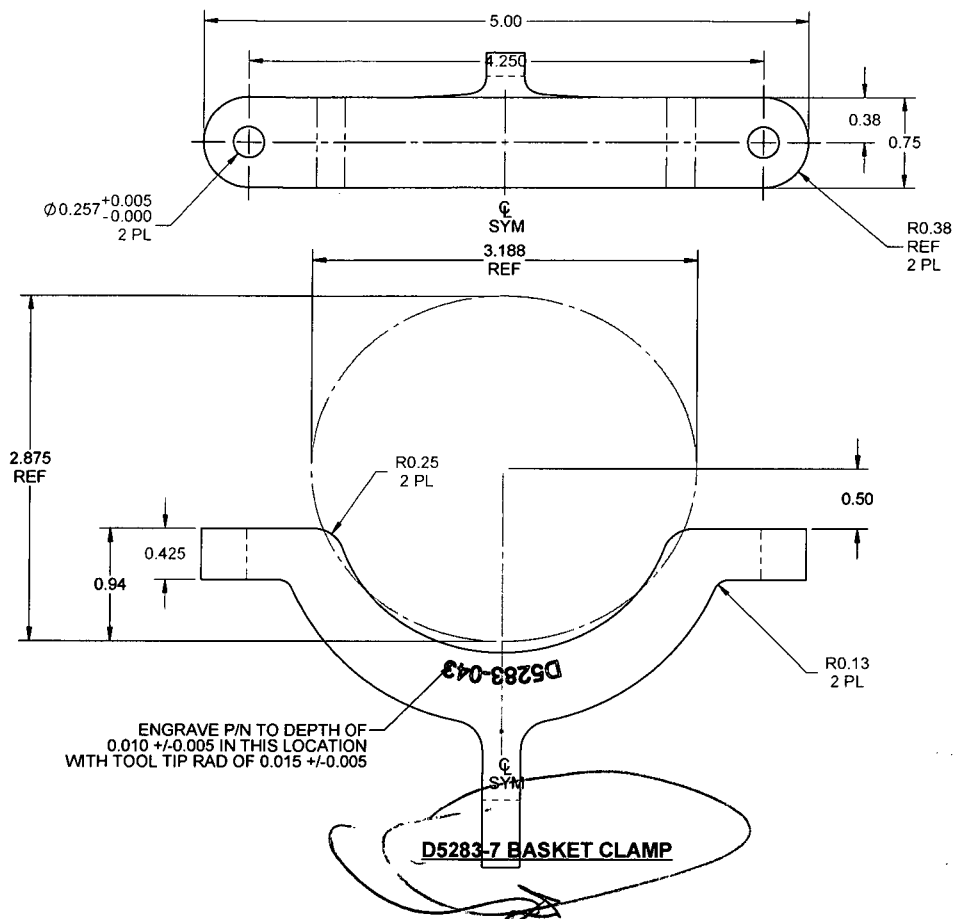


- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AS D5283-043 PER QSI 044 6.3
- 7) WEIGHT: 0.24 lbs
- 8) NON DIMENSIONED FEATURES-REFER TO 3D CAD FILE D5283-3.Rev A. STEP
- 9) MASK BEARING BORE PRIOR TO POWDER COAT

UNAPPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D5283 TITLE BASKET CLAMP ASSY COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. THE EXPRESS OR IMPLIED WARRANTY SET FORTH HEREIN IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY OTHER MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	REV. A2
DRAWN	DB		SHEET 4 OF 4
CHECKED	AP		SCALE
MFG. APPR.	JLM		NT
APPROVED			
DE APPR.			
DATE	15.06.30		

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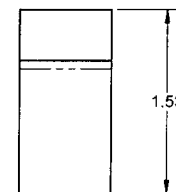
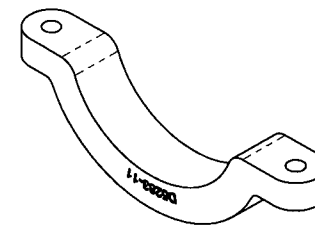
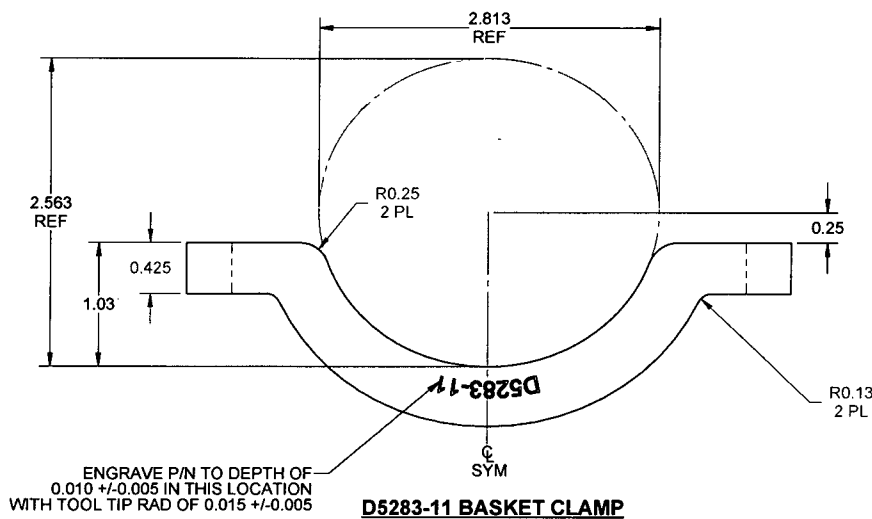
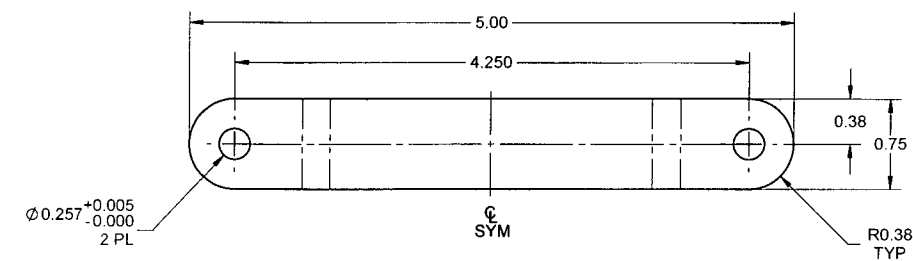


NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 PER DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AS D5283-7 PER QSI 044 6.3
- 7) WEIGHT: 0.24 lbs
- 8) NON DIMENSIONED FEATURES-REFER TO 3D CAD FILE D5283-7.Rev A.SHEP

UNAPPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. A20
MFG. APPR.	JLM	D5283	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET CLAMP ASSY	NTS
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NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 PER DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AS D5283-11 PER QSI 044 6.3
- 7) WEIGHT: 0.20 lbs
- 8) NON DIMENSIONED FEATURES-REFER TO 3D CAD FILE D5283-11.Rev A.STEP

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MFG. APPR.	JLM	D5283	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET CLAMP ASSY	NTS
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DART AEROSPACE LTD		Work Order: 134652
Description: Basket Clamp Assembly		Part Number: D5283-41
Inspection Dwg: D5283 Rev: A20		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.25	+ 0.030	5.250	✓		MIP-09	vern
4.500	+ 0.010	4.500	✓		...	...
0.38	+ 0.030	0.379	✓		↓	↓
0.75	+ 0.030	0.750	✓		↓	↓
Ø 0.257	+ 0.005 - 0.000	0.260	✓		↓	↓
2.82	+ 0.030	2.817	✓		31006	Height gauge
0.425	+ 0.010	0.423	✓		MIP-09	vern
0.313	+ 0.010	0.313	✓		...	...
0.94	+ 0.030	0.936	✓		31006	Height gauge
R 0.13	+ 0.030	0.125	✓		—	Radius gauge
R 0.25	+ 0.030	0.250	✓		↓	↓
R 0.38	+ 0.030	0.375	✓		↓	↓
2.26	+ 0.030	2.260	✓		31006	Height gauge
0.56	+ 0.030	0.558	✓		↓	↓
1.120	+ 0.010	1.120	✓		↓	↓
0.8110 / 0.8115	—	0.8115	✓		MIP-09	vern / bearing Ref
R 0.50	+ 0.030	0.500	✓		—	gauge pin

Measured by: <i>[Signature]</i>	Audited by:	Preliminary Approval:
Date: 15/07/15	Date:	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

[Signature] 10.04.15

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID/Vendor Name		VC-RYS001	Ryerson Canada								
PO20192	8		M6061T6B1.500X01. f 500		6/19/2013	6/20/2013	36.0000	\$4.72	0.0000	0	\$169.96
CAD	No		6061-T6 Bar 1.50 x f 1.50		36.0000	DESJ02		\$169.96	0.0000	0	
	9		M126075		6/19/2013	6/20/2013	24.0000	\$12.59	0.0000	0	\$302.15
	No		M6061T6B1.500X04. f 000		24.0000	DESJ02		\$302.15	0.0000	0	
			6061T6 Bar 1.500 x f 4.00								
			M126075		6/19/2013	6/20/2013	12.0000	\$5.25	0.0000	0	\$62.95
	10		M6061T6B2.000X01. f 250		12.0000	DESJ02		\$62.95	0.0000	0	
	No		6061-T6 Bar 2.00 x f 1.25								
			M126075		6/19/2013	6/20/2013	12.0000	\$9.44	0.0000	0	\$113.31
	11		M6061T6B30000X01 f .500		12.0000	DESJ02		\$113.31	0.0000	0	
	No		6061-T6 Bar 3.00 x f 1.50								
			M126075		6/19/2013	6/20/2013	336.0000	\$1.89	0.0000	0	\$633.82
	12		M6061T6S.063 : sf		320.0000	DESJ02		\$633.82	0.0000	0	
	No		6061-T6 .063 Sheet sf								
			M126075		6/19/2013	6/20/2013	32.0000	\$3.91	0.0000	0	\$125.22
	13		M6061T6S.125 sf		32.0000	DESJ02		\$125.22	0.0000	0	
	No		6061-T6 .125 Sheet sf								
			M126075		6/19/2013	6/20/2013	192.0000	\$7.29	0.0000	0	\$1,400.45
	14		M304S11GA sf		192.0000	DESJ02		\$1,400.45	0.0000	0	
	No		304/316 0.125 Sheet sf								
			M126075		6/19/2013	6/20/2013	128.0000	\$4.46	0.0000	0	\$570.98
	15		M304S14GA sf		128.0000	DESJ02		\$570.98	0.0000	0	
	No		304SS sheet .080 sf								
			M126075								

Total Received Quantity:	952.0000
Total Qty to Inspect (PO U/M):	0.0000
Total Reject Quantity:	0.0000
Total Receipt Value:	\$4,607.24
Total Balance Due Quantity:	0.0000

RYERSON

Shipping Order / Bordereau d'expédition

MO #

200 RUE DU CHEMINOT

200 RUE DU CHEMINOT

Phone/Tel (450) 424-0153

VAUDREUIL-DORION QC J7V 5V5

VAUDREUIL QC J7V 5V5

Sold to/Facteur a:

DART AEROSPACE LTD.

1270, ABERDEEN STREET

Ship to/Expédier a:

DART AEROSPACE LTD.

1270, ABERDEEN STREET

Page 3 de 5 06/19/13 17:54 CST

SO

AP

S.O. / Bordereau d'expédition

X6-310685

P.O. / Bon de commande

20192

HAWKESBURY

ON K6A 1K7

HAWKESBURY

ON K6A 1K7

Phone/Tel (613) 632-3336

Qty Shipped/Qté expédiée B.O. Qty/En souffrance

Line /# de ligne	Item	Description				
7	5131-9499	PLAT AL EXTRUDE 6061T6511 COIN CARRE 1 1/2 X 4	X 144			
		Tariff Code / Code tarifaire: 7604.29.00.19				
Qty Comm:	2	Order Qty/Qté commandée	2	UEA	Pcs: 2	2.00 UEA
(0 -PK/WI 169 LINE 1)						
	Cntrl: X6FL9657	C: Z00212048	T: Z00212048		1 pcs Loc EXP	
	Cntrl: X6FL9658	C: 201302069	T: 362889		1 pcs Loc EXP	
*** Filled by Initials/Rempli par initiale: MT						
8	5131-8871	PLAT AL EXTRUDE 6061T6511 COIN CARRE 1 1/4 X 2	X 144			
		Tariff Code / Code tarifaire: 7604.29.00.19				
Qty Comm:	1	Order Qty/Qté commandée	1	UEA	Pcs: 1	1.00 UEA
(0 -PK/WI 35 LINE 1)						
	Cntrl: X6FL8812	C: Z00247012	T: Z00247012		1 pcs Loc EXP	
*** Filled by Initials/Rempli par initiale: MT						
9	5131-9341	PLAT AL EXTRUDE 6061T6511 COIN CARRE 1 1/2 X 3	X 144			
		Tariff Code / Code tarifaire: 7604.29.00.19				
Qty Comm:	1	Order Qty/Qté commandée	1	UEA	Pcs: 1	1.00 UEA
(0 -PK/WI 64 LINE 1)						
	Cntrl: X6FM3298	C: Z00649008	T: Z00649008		1 pcs Loc EXP	
*** Filled by Initials/Rempli par initiale: MT						

Customer/Driver Instructions / Commentaires du client/chauffeur:

HEURES D'OUVERTURE 7H @ 16H LUN @ VEND DECHARGEMENT AU CHARIOT ELEVATEUR AVANT COTE CHAUFFEUR
CFC ET MTR REQUIS A LA LIVRAISON

Packing List/Bordereau de marchandises

Received by/ Reçu Par:

Date:

Acceptance of goods constitutes acceptance of our Terms and Conditions, available on our website at www.Ryerson.com.

or from your sales representative, or by calling (800) 268-2680.

L'acceptation des marchandises constitue un consentement à nos termes et conditions, qui sont disponibles

sur notre site web www.ryerson.com, ou par votre représentant interne, ou par téléphone (800) 268-2680.

Alloys of Aluminum, Copper, Steel Caution:

Processing of this material may present a physical and or health hazard. See material safety data sheets for further information

Les alliages d'aluminium, de cuivre, d'acier Avertissement:
le Traitement de ce matériel peut présenter un risque physique et ou pour la santé. Pour de plus ample information voir les fiches.

DART AEROSPACE LTD. P.O. - 20192 S.O. - 310685

KAISER ALUMINUM

FABRICATED PRODUCTS

Best in Class

CERTIFIED TEST REPORT

<http://Online.KaiserAluminum.com>

KAISER ALUMINUM
FABRICATED PRODUCTS, LLC
5205 KAISER DRIVE
KALAMAZOO, MI 49048

CUSTOMER PO NUMBER: 727773-1		CUSTOMER PART NUMBER: 51319499		PRODUCT DESCRIPTION: KAISERSELECT SC MANIFOLD BAR 1.50 X 4.00	
KAISER ORDER NUMBER: 633045	LINE ITEM: 001	SHIP DATE: 12/04/2012	KAISER LOT NUMBER: Z00212048	ALLOY: 6061	TEMPER: T6511B
WEIGHT SHIPPED: 513.000 LB	QUANTITY: 6.000 PCS	B/L NUMBER: 605039	DIAM/DAFT/HKNS:	WIDTH:	LENGTH: 12.000 FT
SHIP TO: RYERSON 161 THE WEST MALL ETOBICOKE, ON M9C4V8 CANADA			SOLD TO: RYERSON 161 THE WEST MALL ETOBICOKE, ON M9C4V8 CANADA 5/3/6/20		

Actual Physical Properties

REFERENCE	DASH#	SAMPLE#	UTS (KSI)	YTS (KSI)	ELONG%	HARDNESS	CONDUCT.	BEND
Z00212048	0001	1	45.9	43.7	13.1	RE 95	N/A	N/A

Chemical Composition (wt%), Aluminum Remainder

LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Zr	Ea	Tot
Maximum	0.80	0.70	0.40	0.15	1.20	0.35	0.25	0.15	NA	NA	NA	0.05	0.15
Minimum	0.40	0.00	0.15	0.00	0.80	0.04	0.00	0.00	NA	NA	NA	0.00	0.00
102146	.74	.30	.28	.09	.93	.09	.03	.03	.00	.00	.00	.01	.03

Applicable Requirements:

MANIFOLD BAR, SPECIAL STENCIL PER ASTM-B221-12, STENCILED PER AMS-QQ-A-200/8 (2007)
ASME-SB221 1998 SECT. II MEETS ALL SPECIFICATION REQUIREMENTS FOR 6061-T6511/T6
ELEVATED MINIMUM MECHANICAL PROPERTIES AS FOLLOWS: UTS = 42.0 KSI MIN YIELD = 38.0 KSI
MIN ELONGATION = 10.0% MIN

Miscellaneous Notes

MANUFACTURED IN USA MELTED IN USA

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

Calvin Latting, Quality & Technology Manager

Calvin Latting

Plant Serial: 00069071
Kaiser Order Number: 633045
Line Item: 001



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO20192

Purchase Order Date 6/14/2013

PO Print Date 6/14/2013

Page Number 3 of 5

Order From :
RYERSON
200 DU CHEMINOT
VAUDREUIL, QUEBEC J7V 5V5

VC-RYS001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 450-424-0153

Ship To Contact
Ship To Phone
Ship Via: Yours ppd
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

7	M6061T6B1.000X12.000	6061-T6 Bar 1.00 x 12.00	6/19/2013	24.00	✓	\$626.58
	AS ABOVE		Yes 6/19/2013	f	<i>[Signature]</i>	

Line Total: \$626.58

8	M6061T6B1.500X01.500	6061-T6 Bar 1.50 x 1.50	6/19/2013	36.00	✗	\$176.22
	AS ABOVE		Yes 6/19/2013	f	<i>[Signature]</i>	

Line Total: \$176.22

9	M6061T6B1.500X04.000	6061T6 Bar 1.500 x 4.00	6/19/2013	24.00	✓	\$313.27
	AS ABOVE		Yes 6/19/2013	f	<i>[Signature]</i>	

Line Total: \$313.27

10	M6061T6B2.000X01.250	6061-T6 Bar 2.00 x 1.25	6/19/2013	12.00	✓	\$65.27
	AS ABOVE		Yes 6/19/2013	f	<i>[Signature]</i>	

Note:

6/14/2013

Work Order ID 131130

March-26-15 1:44:02 PM

131130

Page 1

Item ID: D2611 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearing
 Start Date: 3/26/15 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 3/26/15 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: MLD Date: 15-03-31 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2611	Rev C								

100 PURCHASING 0.00
100
 Purchasing Memo 0.00
 Purchasing Issue P/O: 27963 Purchase part as per Dwg D2611 Possible supplier:
 McMasterP/N: 63215K34 Material release note required CL 15/03/31 40

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
 Packaging Memo 0.00
 Packaging Ensure certificate of conformity is attached 40x 8015-042

120 QC6- Inspect dimensions to drawing 0.00
120
 QC Memo 0.00
 Quality Control 40 DAS 38
 APP 06-2015

Work Order ID 131130

March-26-15 1:44:02 PM

131130

Page 2

Item ID: D2611

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Bearing

Stop *NS2*

Start Date: 3/26/15 Start Qty: 40.00

40

Cust Item ID:

Required Date: 3/26/15 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>STORA</u>	0.00				40	DAS 27		
130									
Packaging	Memo	0.00							
Packaging									
									APR 07 2015
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

ML5 1804-07

15.47

March-26-15 1:44:02 PM

Page 1

131130

D2611

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

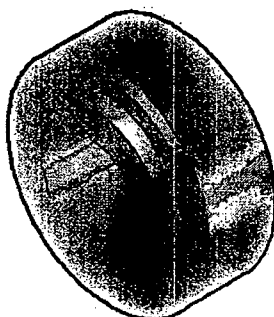
40

Bearing



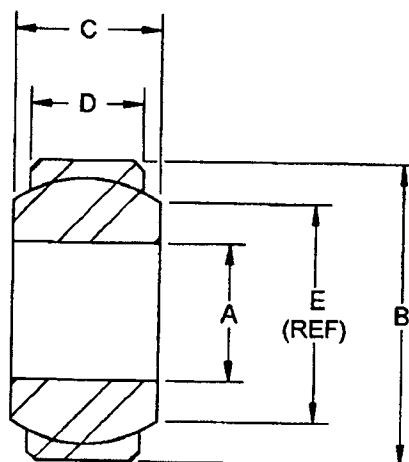
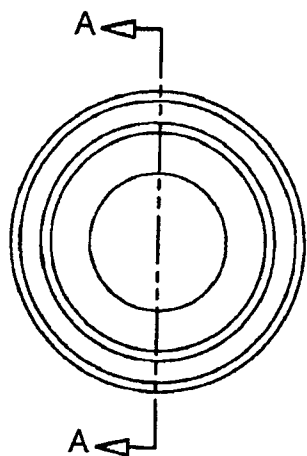
DESIGN <i>qp</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2611	REV. C SHEET 1 OF 1
DATE 06.09.20		TITLE BEARING	
REV	DATE	DESCRIPTION	
A	97.07.31	NEW ISSUE	
B	01.07.04	RE-DRAWN	
C	06.09.20	CHANGE TO SS; CHANGE SUPPLIER	

SPECIFICATION CONTROL DRAWING



RELEASED

06.11.17 *#*



SECTION A-A

UNCO
STAINLESS
STEEL
MATERIAL
NO. 131130 M45
1503-31

A	B	C	D	E (REF)	POSSIBLE SUPPLIER
0.375	0.813	0.406	0.313	0.592	McMASTER-CARR P/N 63215K34

NOTES:

- 1) STAINLESS STEEL BALL JOINT SWIVEL BEARING
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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RT
SPACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO27963

Purchase Order Date 3/31/2015

PO Print Date 3/31/2015

Page Number 3 of 4

Order From :

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

330 995 5500

Ship To Contact

Ship To Phone

Ship Via:

FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

USD

FOB

FCA - (Free Carrier)

6 63215K34

Bearing

4/1/2015

40.00

\$17.24

\$689.60

Yes

Each

4/1/2015

AS PER DWG D2611 REV. C
B131130

SP15-01-2

Line Total:

\$689.60

7 71550-11

9198K16 303 ROUND
BAR 5" DIA

4/1/2015

1.00

\$154.08

\$154.08

Yes

Each

4/1/2015

1 PCS OF 3 FT

Line Total:

\$154.08

Deliver To: JEAN-LUC

8 71400-40

19525T13 HIGH
TEMPERATURE CASTER

4/1/2015

4.00

\$23.53

\$94.12

Yes

Each

4/1/2015

Line Total:

\$94.12

Deliver To: LUC

Note:

3/31/2015

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada
Attention: Deliver To Luc

Purchase Order
PO27963

Order Placed By
Chantal Lavoie

McMaster-Carr Number
1428983-01

Page 1 of 1

03/31/2015

Line	Product	Ordered	Shipped
1	8568K186 High-Strength Multipurpose Neoprene Rubber, 1/2" Thick, 12" X 24", 60A Durometer	1 Each	1 ✓
2	91343A100 Type 316 Stainless Steel Serrated-Flange Locknut, 1/4"-20 Thread, 19/32" Flange Diameter, 15/64" Overall HT., Packs of 10	5 Packs	5 ✓
3	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread	8 Each	8 ✓
4	91525A120 Type 316 Stainless Steel Flat Washer, Oversized, 1/4" Screw Size, 0.281" ID, 1.000" OD, Packs of 25	2 Packs	2 ✓
5	95606A170 Nylon Flat Washer, 7/16" Screw Size, 0.500" ID, 0.688" OD, Off-White, Packs of 100	1 Pack	1 ✓
6	63215K34 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 3/8" ID, 13/16" OD, 13/32" Ball Thick	40 Each	40 ✓
7	9198K16 Easy-to-Machine 303 Stainless Steel Rod, 5" Diameter, 3" Long	1 Each	1 ✓
8	19525T13 Nonmarking High-Temperature Caster, Swivel, 4" X 1-1/4" Brown Nylon Wheel, 300# Capacity Your Part Number: 71400-40	4 Each	4 ✓
9	19525T17 Nonmarking High-Temperature Caster, Rigid, 4" X 1-1/4" Brown Nylon Wheel, 300# Capacity, Deliver To Luc Your Part Number: 71400-40	4 Each	4 ✓

McMaster-Carr Supply Company
200 Aurora Industrial Pkwy
Aurora, OH 44202-8087 USA
Phone: 330-995-5500 Fax: 330-995-9600
E-Mail: cle.sales@mcmaster.com
Employer Identification Number (EIN): 36-1458720

Invoice: 26682794
Purchase Order: PO27963
Release:
McMaster-Carr Number: 1428983-01

ORIGINAL COMMERCIAL
INVOICE
CERTIFICATE OF ORIGIN

Ultimate Destination:
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Shipped: 31-Mar-2015 FOB: ORIGIN
Shipper's Export Declaration (SED):
NO EEI 30.36

Intermediate Consignee:

Bill To:
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Tax Number:

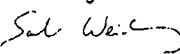
Forwarding Agent:

Billing
Attention:
Shipping Deliver To Luc
Attention:
Contact:

Line	Description	Qty & Unit	Unit Price	Extension
1	8568K186 High-Strength Multipurpose Neoprene Rubber, 1/2" Thick, 12" X 24", 60A Durometer Country of Origin: United States Schedule B #: 400821 ECCN #: EAR99 NLR	1 EA	\$102.55	\$102.55
2	91343A100 Type 316 Stainless Steel Serrated-Flange Locknut, 1/4"-20 Thread, 19/32" Flange Diameter, 15/64" Overall HT., Packs of 10 Country of Origin: Taiwan Schedule B #: 731816 ECCN #: EAR99 NLR	5 PK	\$3.83	\$19.15
3	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread Country of Origin: United States Schedule B #: 848330 ECCN #: EAR99 NLR	8 EA	\$17.14	\$137.12
4	91525A120 Type 316 Stainless Steel Flat Washer, Oversized, 1/4" Screw Size, 0.281" ID, 1.000" OD, Packs of 25 Country of Origin: Taiwan Schedule B #: 731822 ECCN #: EAR99 NLR	2 PK	\$6.66	\$13.32

Your order is subject only to our terms and conditions, available at www.mcmaster.com or from our Sales Department.

These commodities, technology, or software were exported from the United States in accordance with Export Administration regulations. Diversion contrary to US law is prohibited.

Shipping Weight (In kgs): 21	Number of Packages: 1	Invoice Amounts:	Merchandise Amount: \$1,284.06 Total (In USD): \$1,284.06
Package Dimensions: 64 X 33 X 34 CM = .071 CUBIC M		Payment Terms: 2% discount on merchandise only if paid within 10 days, net 30 days	
Authorized Signature: 	Date: 31-Mar-2015	Remit payment to: (by mail) McMaster-Carr Supply Company PO Box 7690 Chicago, IL 60680-7690 USA (by wire transfer) Bank of America Illinois 231 S LaSalle Chicago, IL 60697 ABA 071000039 Account 86666-02021 SWIFT BOFAUS3N	
Name: Sarah Weinberg	Title: Operations Mgr.	Page 1 of 2	

McMaster-Carr Supply Company
 200 Aurora Industrial Pkwy
 Aurora, OH 44202-8087 USA
 Phone: 330-995-5500 Fax: 330-995-9600
 E-Mail: cle.sales@mcmaster.com
 Employer Identification Number (EIN): 36-1458720

Invoice: 26682794
 Purchase Order: PO27963
 Release:
 McMaster-Carr Number: 1428983-01

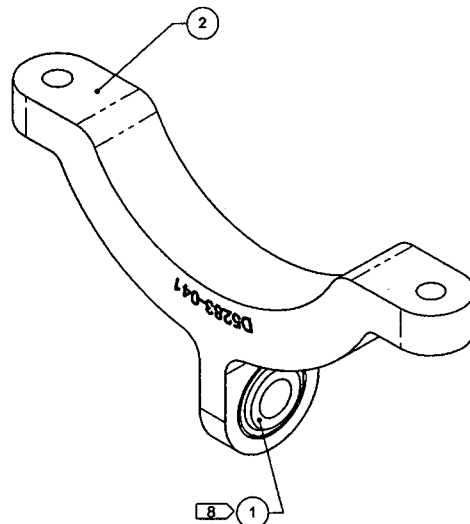
ORIGINAL COMMERCIAL
INVOICE
 CERTIFICATE OF ORIGIN

Line	Description	Qty & Unit	Unit Price	Extension
5	95606A170 Nylon Flat Washer, 7/16" Screw Size, 0.500" ID, 0.688" OD, Off-White, Packs of 100 Country of Origin: United States Schedule B #: 392690 ECCN #: EAR99 NLR	1 PK	\$8.60	\$8.60
6	63215K34 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 3/8" ID, 13/16" OD, 13/32" Ball Thick Country of Origin: Peoples Republic of China Schedule B #: 848330 ECCN #: EAR99 NLR	40 EA	\$17.24	\$689.60
7	9198K16 Easy-to-Machine 303 Stainless Steel Rod, 5" Diameter, 3" Long Country of Origin: Sweden Schedule B #: 722211 ECCN #: EAR99 NLR	1 EA	\$154.08	\$154.08
8	19525T13 Nonmarking High-Temperature Caster, Swivel, 4" X 1-1/4" Brown Nylon Wheel, 300# Capacity, 71400-40 Country of Origin: Peoples Republic of China Schedule B #: 871690 ECCN #: EAR99 NLR	4 EA	\$23.53	\$94.12
9	19525T17 Nonmarking High-Temperature Caster, Rigid, 4" X 1-1/4" Brown Nylon Wheel, 300# Capacity, Deliver To Luc, 71400-40 Country of Origin: Peoples Republic of China Schedule B #: 871690 ECCN #: EAR99 NLR	4 EA	\$16.38	\$65.52
	NOTE Tracking number(s) for this shipment: 633862298275			

Number of Packages: 1

Page 2 of 2

ITEM	QTY	P/N	DESCRIPTION
	X	D5283-041	BASKET CLAMP ASSY
1	1	D2611	BEARING
2	1	D5283-1	BASKET CLAMP



D5283-041 BASKET CLAMP ASSY

NOTES:

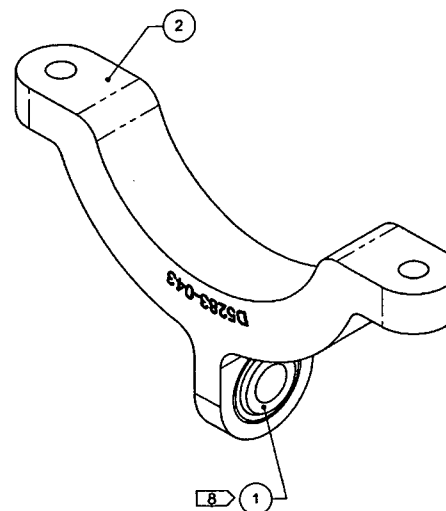
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs
- 8) PRESS FIT D2611 BEARING AND STAKE 4 PLACES PER SIDE

RELEASED
2015-07-20
ECN 15-607

A		NEW ISSUE		DB	15.06.30
REV.	DESCRIPTION			BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	DB				
CHECKED	AP	DRAWING NO.	REV. A		
MFG. APPR.	JLM	D5283	SHEET 1 OF 8		
APPROVED	WM	TITLE	SCALE		
DE APPR.	DS	BASKET CLAMP ASSY	NTS		
DATE	15.06.30		COPYRIGHT © 2015 BY DART AEROSPACE LTD		
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APPROVED

ITEM	QTY	P/N	DESCRIPTION
	X	D5283-043	BASKET CLAMP ASSY
1	1	D2611	BEARING
2	1	D5283-3	BASKET CLAMP



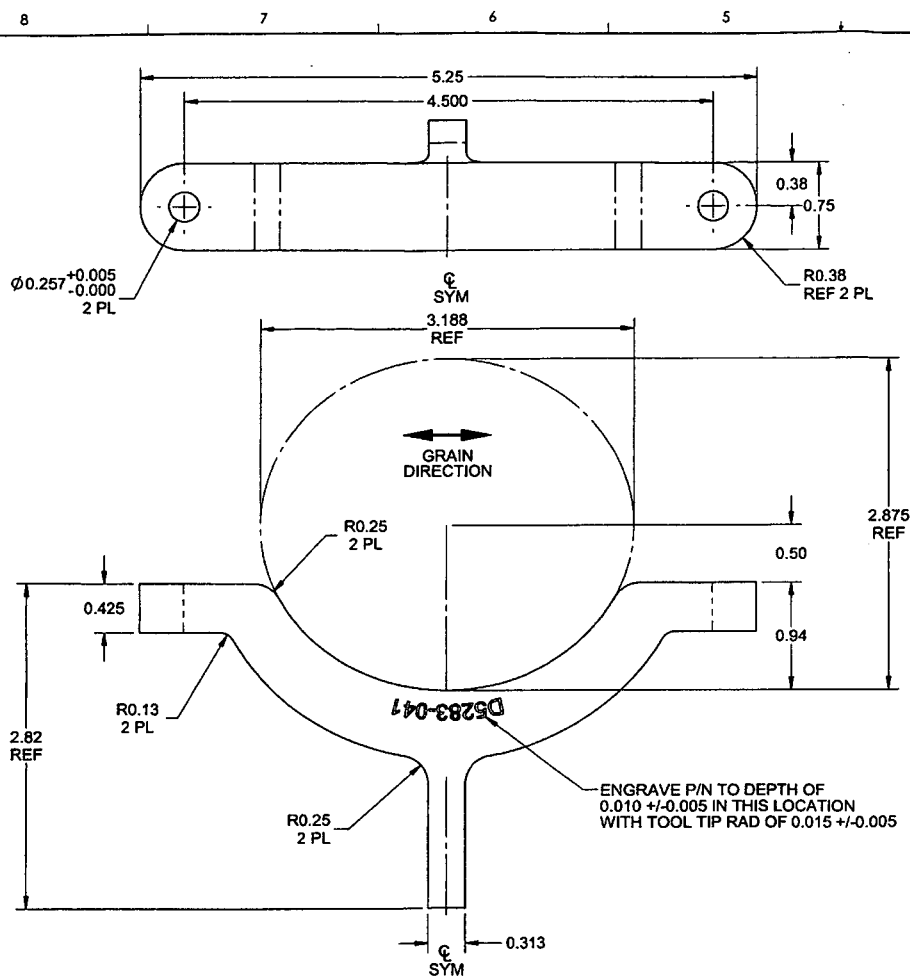
D5283-043 BASKET CLAMP ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs
- 8) PRESS FIT D2611 BEARING AND STAKE 4 PLACES PER SIDE

RELEASED
2015-07-20

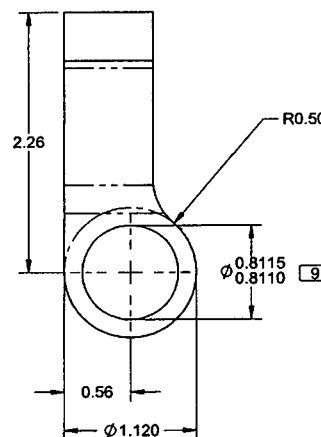
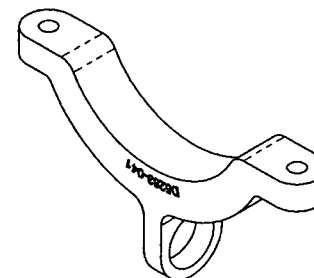
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	DRAWN	DB		
	CHECKED	AP	DRAWING NO.	REV. A
	MFG. APPR.	JLM	D5283	SHEET 2 OF 6
	APPROVED	WM	TITLE	SCALE
	DE APPR.	DS	BASKET CLAMP ASSY	NTS
DATE		15.06.30	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D5283-1 BASKET CLAMP

NOTES:

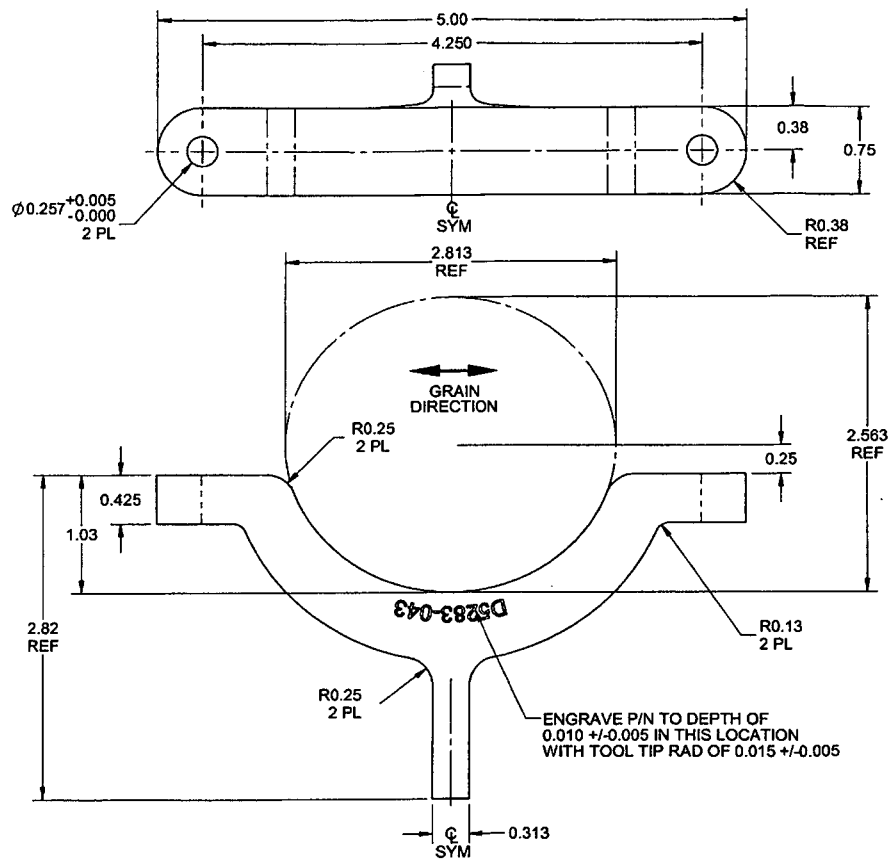
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 PER DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AS D5283-041 PER QSI 044 6.3
- 7) WEIGHT: 0.24 lbs
- 8) NON DIMENSIONED FEATURES-REFER TO 3D CAD FILE D5283-1.Rev A.STEP
- 9) MASK BEARING BORE PRIOR TO POWDER COAT



RELEASED
2015-07-20

APPROVED

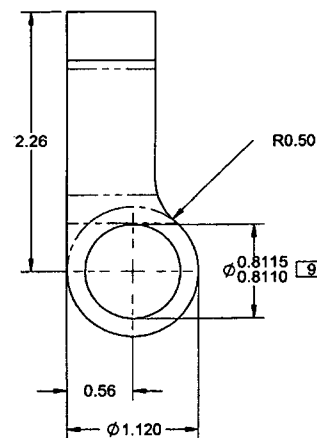
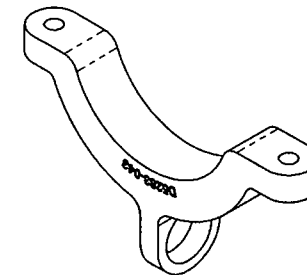
DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5283	SHEET 3 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	BASKET CLAMP ASSY	NTS
DATE	15.06.30	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D5283-3 BASKET CLAMP

NOTES:

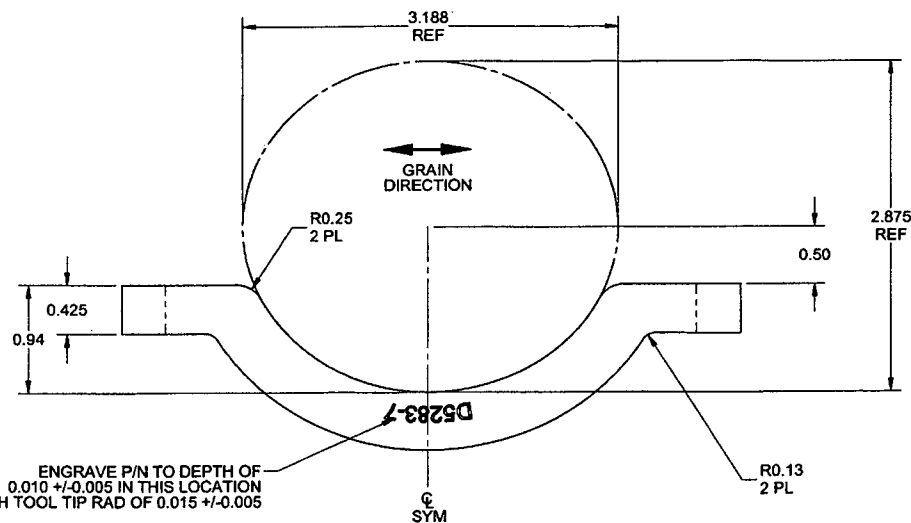
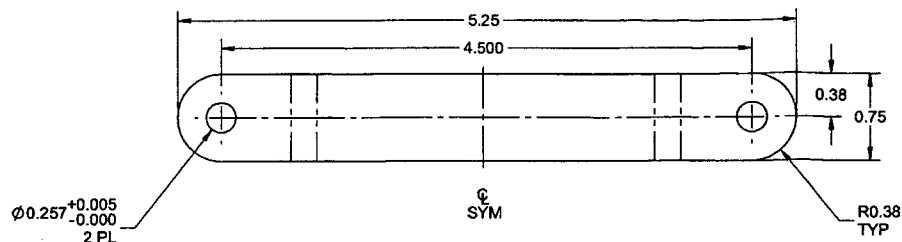
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 PER DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AS D5283-043 PER QSI 044 6.3
- 7) WEIGHT: 0.24 lbs
- 8) NON DIMENSIONED FEATURES-REFER TO 3D CAD FILE D5283-3.Rev A. STEP
- 9) MASK BEARING BORE PRIOR TO POWDER COAT



RELEASED
2015-07-20

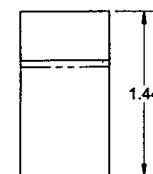
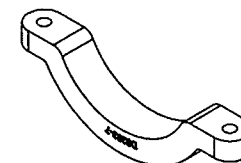
APPROVED

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5283	SHEET 4 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	BASKET CLAMP ASSY	NTS
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ENGRAVE P/N TO DEPTH OF
0.010 +/-0.005 IN THIS LOCATION
WITH TOOL TIP RAD OF 0.015 +/-0.005

D5283-7 BASKET CLAMP



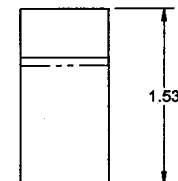
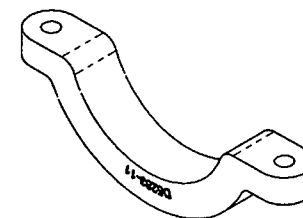
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 PER DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AS D5283-7 PER QSI 044 6.3
- 7) WEIGHT: 0.20 lbs
- 8) NON DIMENSIONED FEATURES-REFER TO 3D CAD FILE D5283-7.Rev A.STEP

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MFG. APPR.	JLM	D5283	SHEET 5 OF 6
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DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5283	SHEET 6 OF 6
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DE APPR.	DS	BASKET CLAMP ASSY	
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